

Date: Monday, 2/5/2007 8:08:51 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING	
Job Number	: 30616		Part Number	: D32163	
Estimate Number	: 10870		Drawing Number	: D3216 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/5/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/9/2007	
Previous Run	: 29141		Qty:	20	Um: Each
Written By					
Checked & Approved By					
Comment	: Est: A 93.10.28 New Issue KJ/RF				
	: Est Rev:B Now on Waterjet 06-07-03 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 .125 Sheet
Comment: Qty.: 0.0302 sf(s)/Unit Total : 0.6048 sf(s) 304/316 .125 Sheet (M304S0125) Batch: M102817 <i>M1 07 02 14</i> (20)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3216 Dwg Rev: <u>A</u> <i>M1 07 02 14</i> (20) Prog Rev: <u>A</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<i>M1 07 02 14</i> (20)		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<i>07 02 14 20</i> (20)		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<i>07 02 23 88</i> (20)		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. Tumble until parts have a polished finish.		
<i>07 02 19 88</i> (20)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/06
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:08:51 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 30616

Part Number: D32163

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2/3 07/02/23 (2d)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5

1/2/23 (2d)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/3 07/02/23 (2d)

Job Completion



1/2/23 (2d)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

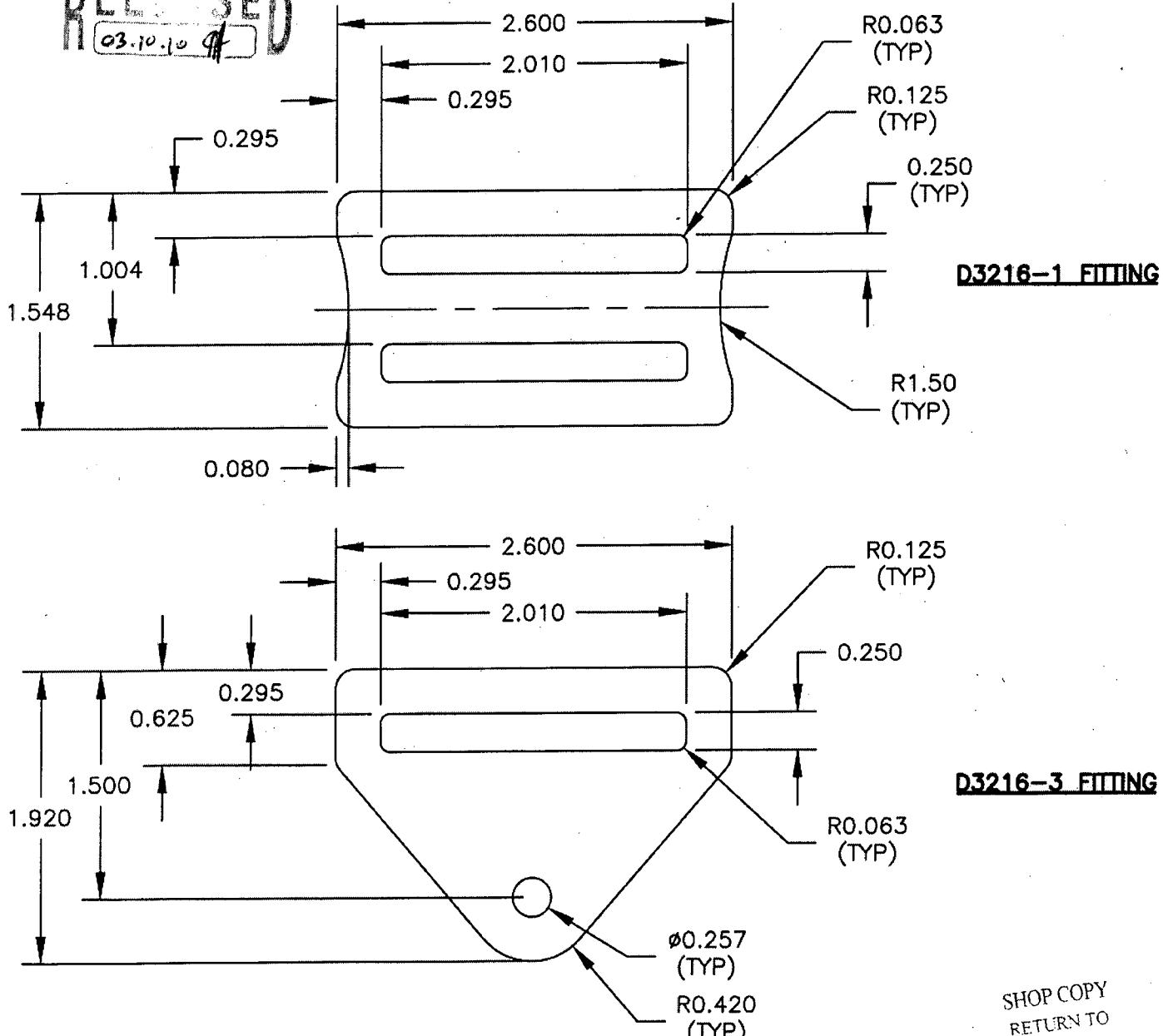
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3216	SHEET 1 OF 1
DATE		TITLE	SCALE
03.09.26		FITTING	1:1
A	03.09.26	NEW ISSUE	

RELEASED
03.10.10**D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30616

DART AEROSPACE LTD	Work Order:	30616
Description: Fitting	Part Number:	D3216-3
Inspection Dwg: D3216 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>Mr. M</u>
Date:	07/02/14

Audited by:	<i>[Signature]</i>
Date:	07.02.14

Prototype Approval:	<i>[Signature]</i>
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	